

# Work Order ID 82832

Wednesday, November 28, 2012 3:06:20 PM

**\*82832\***

Page 1

Item ID: D3213-041

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Door Assembly

Stop

**\*NS2\***

Start Date: 4/10/2012 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 4/20/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals: Process Plan: MF

Date: 12-11-28

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3213

B

100

0.00

**\*100\***

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Assemble as per Dwg D3213 Transfer drill hinge using DT8470 & DT9520

Identify as D3213-041

110

QC5- Inspect part completeness to step on W/O

0.00

**\*110\***

QC

Memo

0.00

Quality Control

120

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

**\*120\***

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

W121279

3200F

4-10

10X 12/12/04

10

10X 12/12/04

**\*82832\***

Wednesday, November 28, 2012 3:06:20 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 4/10/2012      **Start Qty:** 12.00

**\*12\***

**Cust Item ID:**

**Required Date:** 4/20/2012      **Req'd Qty:** 12.00

**\*12\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

0.00

**\*130\***

QC

## Memo

0.00

## Quality Control

0.00

**\*140\***

### Small Fab

## Small Fab

## Memo

0.00

### Small Fab

Assemble as per Dwg D3213

QC5- Inspect part completeness to step on W/O

0.00

**\*150\***

QC

## Memo

0.00

## Quality Control

# Work Order ID 82832

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Item ID: D3213-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Door Assembly  
Start Date: 4/10/2012 Start Qty: 12.00 **\*12\*** Cust Item ID:  
Required Date: 4/20/2012 Req'd Qty: 12.00 **\*12\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>ST211</u>	0.00							
<b>*160*</b>									
Packaging	Memo	0.00				10			12/12/07 JB
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
<b>*170*</b>									
QC	Memo	0.00							12/12/10 JD
Quality Control									

12/12/12

# Picklist Print

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Work Order ID: 82832  
Parent Item: D3213-041  
Parent Item Name: Door Assembly

Start Date: 4/10/2012 Required Date: 4/20/2012  
Start Qty: 12.00 Required Qty: 12.00

Comments: IPP Rev:A New Issue 05-11-17 17:27

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<del>D3161-3</del> Hinge 15.0"		Manufactured	No			100	Each	25.0000	2	24		12/12/03	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST031		25							
				83365		17							
				90835		4							
				91310		4							
<del>D3213-1</del> Door Panel		Manufactured	No			100	Each	19.0000	1	12		12/12/03	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST232		19							
				74538		9							
				83419		10							
<del>D3213-3</del> Door Panel		Manufactured	No			100	Each	20.0000	1	12		12/12/03	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST232		20							
				68907		2							
				74539		8							
				83420		10							
<del>MS20470AD4-6</del> Rivet, Universal Head		Purchased	No			100	Each	3,690.0000	1	12		12/12/05	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST336		3690							
				117395		16							
				118927		143							
				119109		12							
				120142		81							
				121524		65							
				122452		374							
				123021		2999							

B83365 (150)

4

10

10

10

# Picklist Print

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Page 2

Work Order ID: 82832  
Parent Item: D3213-041  
Parent Item Name: Door Assembly

Start Date: 4/10/2012 Required Date: 4/20/2012  
Start Qty: 12.00 Required Qty: 12.00

D2137 Manufactured No  
Decal - No Step

140 Each 39.0000 1 12

Location	Loc Qty	Loc Code
GA	39	
83540	7	
89266	12	
90854	20	

*[Handwritten signature]*  
84438 (4x)

*[Handwritten mark]* D2419  
Handle

Manufactured No

140 Each 16.0000 1 12

Location	Loc Qty	Loc Code
ST010	16	
90070	8	
90849	4	
91306	4	

*[Handwritten signature]*  
B82836 (4x)

~~D2462~~  
Seal

Manufactured No

140 f 283.9349 2.4 28.8

Location	Loc Qty	Loc Code
ST403	283.9349	
48530	283.9349	

*[Handwritten signature]*

~~D2728~~  
Dart Logo label

Manufactured No

140 Each 0.0000 0 0

MS20470AD4-4

Rivet, Universal Head

Purchased No

140 Each 3,663.0000 24 288

Location	Loc Qty	Loc Code
ST336	3663	
116188	136	
116391	66	
118614	309	
119109	26	
121011	5	
121652	130	
122027	2600	
122063	62	
123352	329	

*[Handwritten signature]*  
240

# Picklist Print

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Page 3

Work Order ID: 82832

Parent Item: D3213-041

Parent Item Name: Door Assembly

Start Date: 4/10/2012

Required Date: 4/20/2012

Start Qty: 12.00

Required Qty: 12.00

~~NAS1149DN632J~~

Washer

Purchased

No

140

Each

25.0000

1

12

Location

Loc Qty

Loc Code

ST298

25

118428

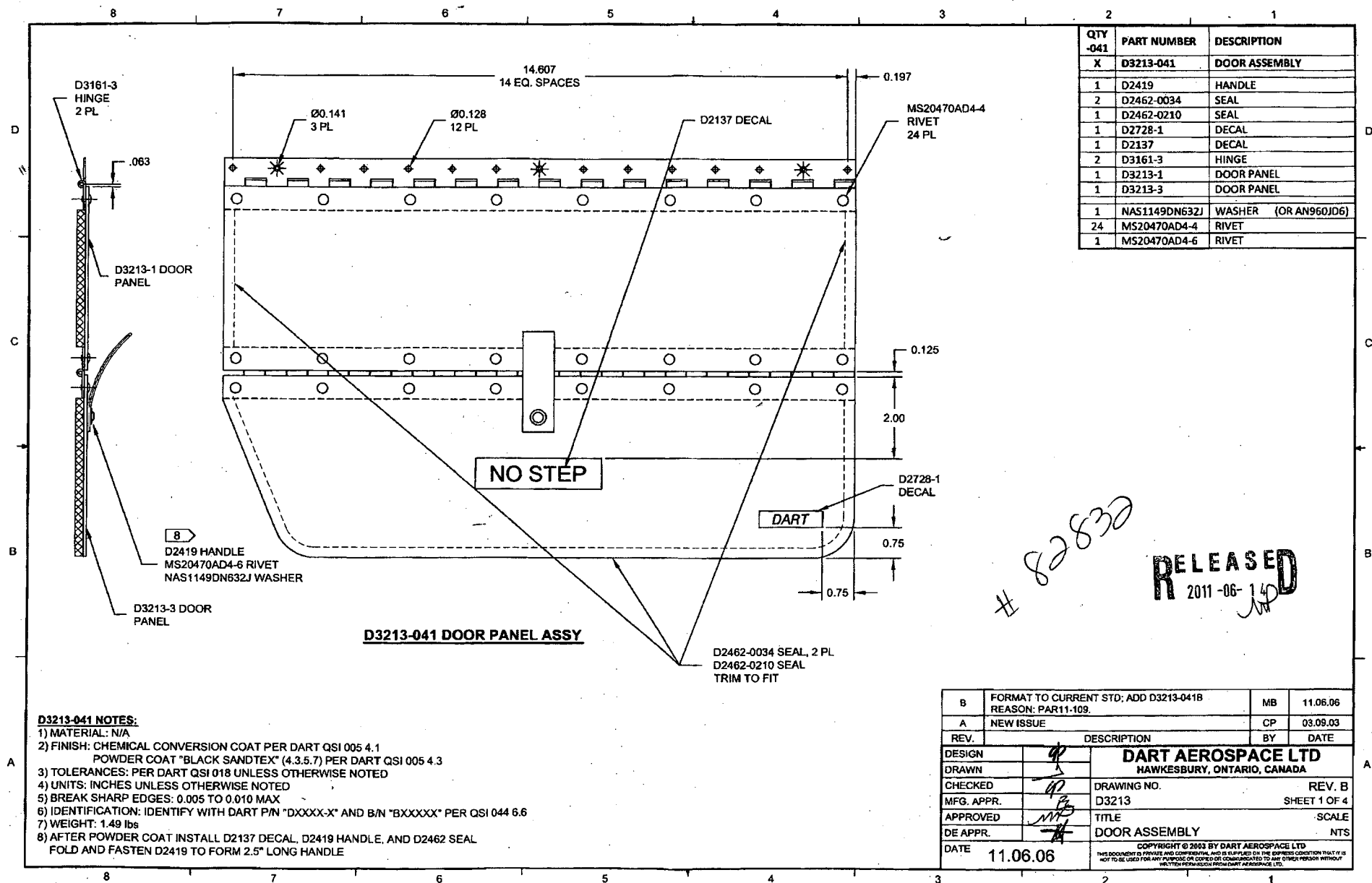
14

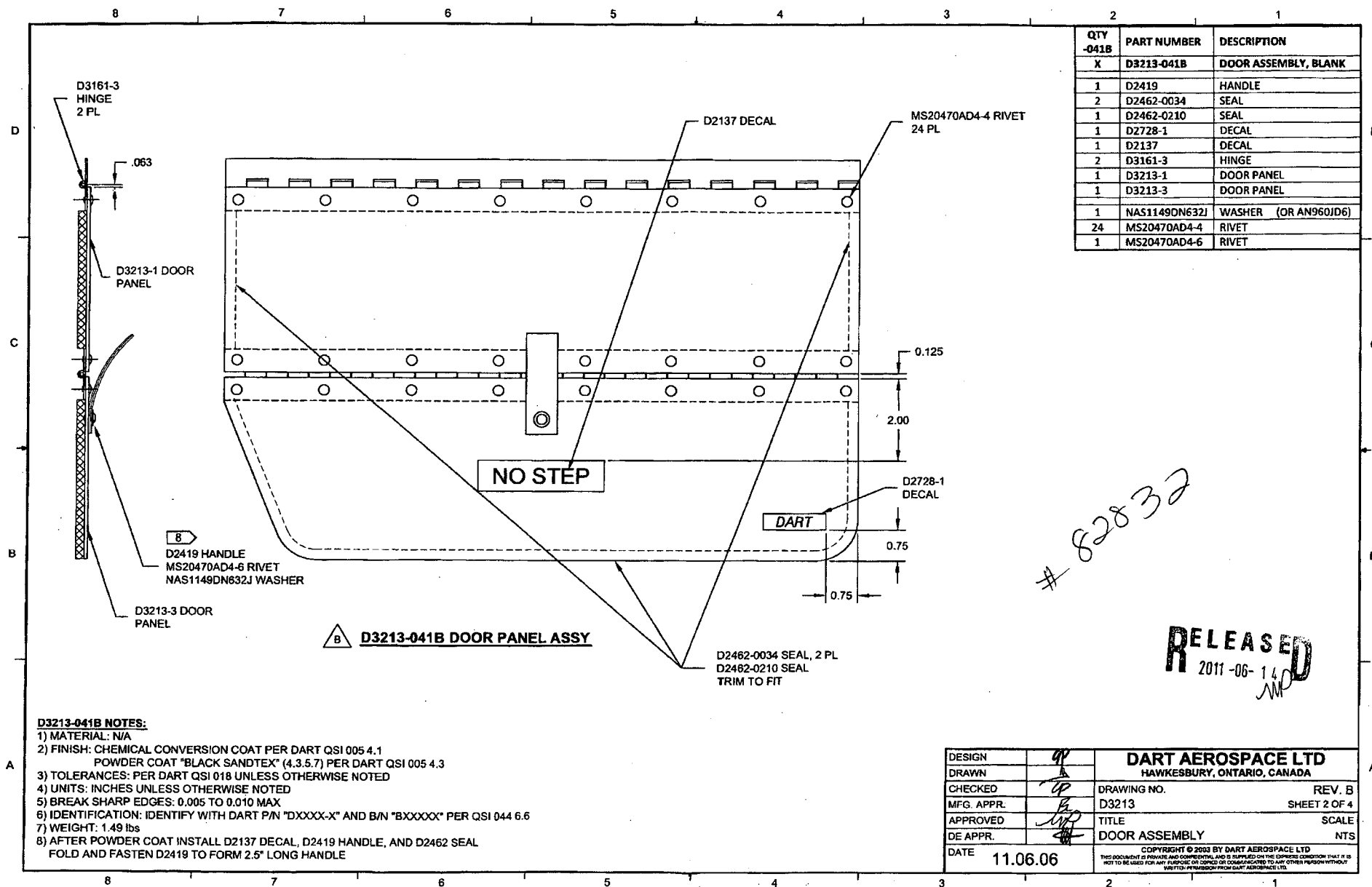
122441

11

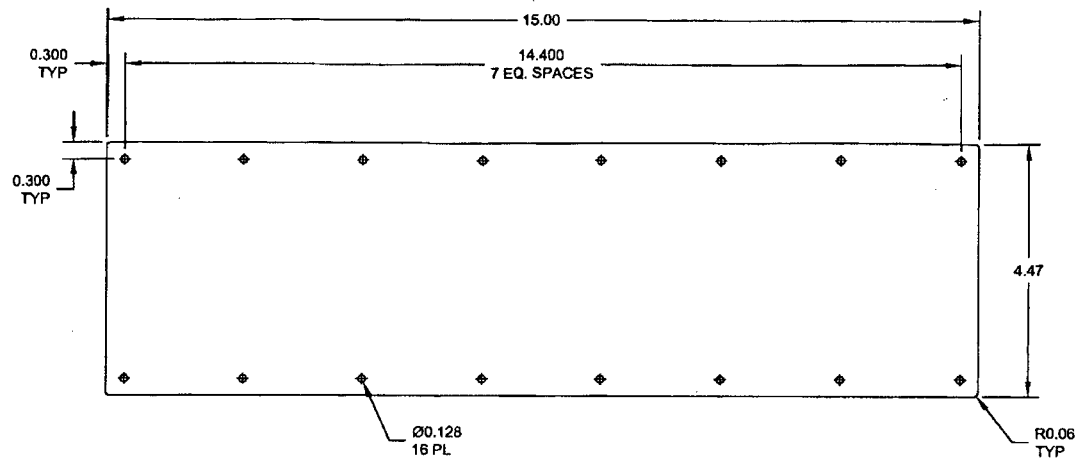
*12/12/05*

*M123900*  
*100*









**D3213-1 DOOR PANEL**

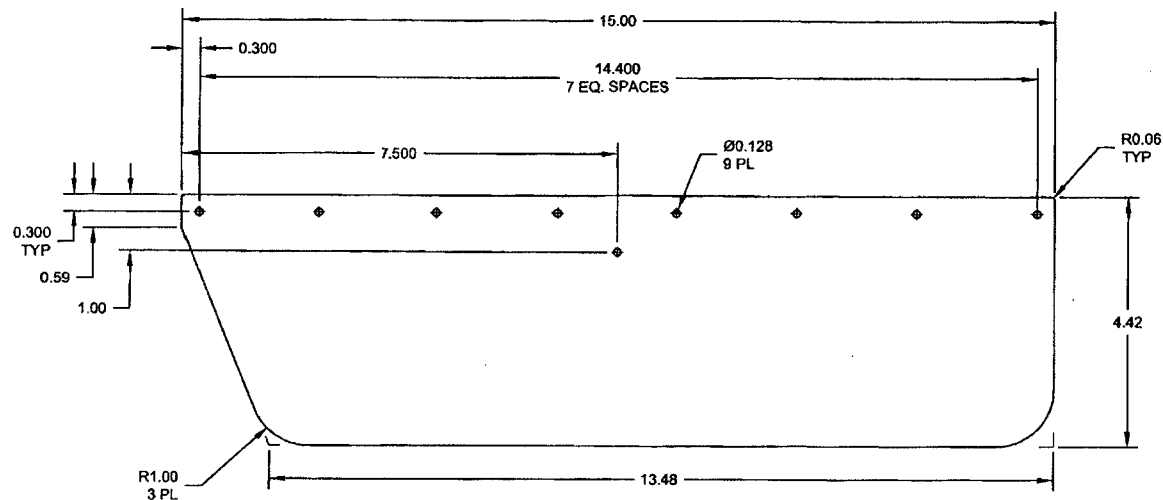
# 82832

**RELEASED**  
2011-06-18

**D3213-1 NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209  
REF. DART SPEC M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.42 lbs

DESIGN	4	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	4		
CHECKED	4	DRAWING NO.	REV. B
MFG. APPR.	4	D3213	SHEET 3 OF 4
APPROVED	4	TITLE	SCALE
DE APPR.	4	DOOR ASSEMBLY	NTS
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**D3213-3 DOOR PANEL**

#82832

**RELEASED**  
2011-06-10  
NR

**D3213-3 NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF. DART SPEC M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.39 lbs

DESIGN	9P	<b>DART AEROSPACE LTD</b>	
DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. B
MFG. APPR.	13	D3213	SHEET 4 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	14	DOOR ASSEMBLY	NTS
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